

Work Order ID 66240

Page 1

February 8, 2011 8:44:03 AM

Item ID: D3536-23

Accept



Setup Start



Revision ID:

Item Name: Gasket

Stop



Start Date: 2/08/11 Start Qty: 10.00



Cust Item ID:

Required Date: 2/22/11 Req'd Qty: 10.00



Customer:

Reference:

Approvals: Process Plan: C8 Date: 11/02/08

Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
D3536	Rev A	

100 0.00

	FLOW WATER JET	<u>BS 11-2-10</u>	_____
--	----------------	-------------------	-------

Waterjet	Memo	0.00	_____
----------	------	------	-------

FLOW CNC Waterjet	1-Cut as per Dwg D3536	<input type="checkbox"/> Dwg Rev: <u>A</u>	<input type="checkbox"/> Prog Rev: <u>A</u>	<input type="checkbox"/> 2-
	Deburr if necessary			

(10)

110 0.00

	QC2- Inspect parts off machine FAI/FAIB	<u>BS 11-2-10</u>	_____
--	---	-------------------	-------

QC	Memo	0.00	_____
----	------	------	-------

Quality Control

120 0.00

	QC8- Inspect parts - second check	<u>BS 11-2-10</u>	_____
--	-----------------------------------	-------------------	-------

QC	Memo	0.00	_____
----	------	------	-------

Quality Control

8ulorlio
(HO)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 66240

February 8, 2011 8:44:03 AM



Page 2

Item ID: D3536-23

Accept



Setup Start



Revision ID:

Item Name: Gasket

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Start Date: 2/08/11

Start Qty: 10.00



Cust Item ID:

Required Date: 2/22/11

Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Identify as per dwg & Stock Location:

0.00

11/21/10 SP/ (102)

Packaging

Packaging

Memo

0.00

140



QC21- Final Inspection - Work Order Release

0.00

11/02/11 MF

QC

Quality Control

Memo

0.00

MF
11-02-11

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 8, 2011 8:44:02 AM

Page 1

Work Order ID: 66240



Parent Item: D3536-23



Parent Item Name: Gasket

Start Date: 2/08/11

Required Date: 2/22/11

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A New Issue 07-02-14 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MNEO60S.063 		Purchased	No			100	sf	177.5000	1.3365	14.85		<i>KB 11-2-10</i>	

NEOPRENE SHEET 0.063

Location	Loc Qty	Loc Code
MAT	177.5	
115916	177.5	
<i>116835</i>		<i>116832</i>

(10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	6624b
Description: Gasket	Part Number:	D3536-23
Inspection Dwg: D3536 Rev: A		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

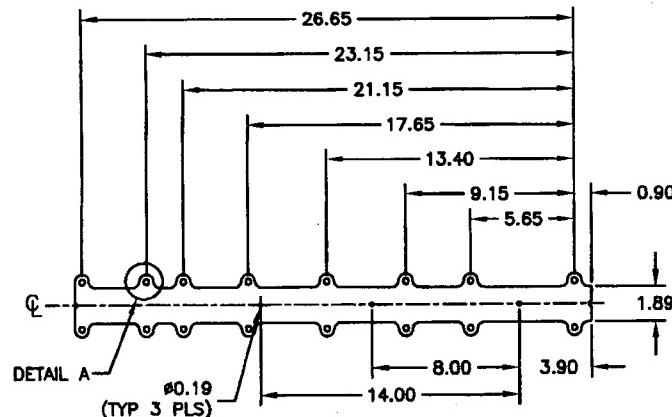
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
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48.20	+/-0.030	48.26	X		T	
44.70	+/-0.030	44.76	X		T	
39.31	+/-0.030	39.31	X		T	
33.92	+/-0.030	33.92	X		T	
28.53	+/-0.030	28.53	X		T	
23.14	+/-0.030	23.14	X		T	
17.75	+/-0.030	17.75	X		T	
14.25	+/-0.030	14.25	X		T	
9.50	+/-0.030	9.50	X		T	
4.75	+/-0.030	4.75	X		T	
8.00	+/-0.030	8.00	Z		T	
16.00	+/-0.030	16.00	X		T	
24.00	+/-0.030	24.00	Z		T	
32.00	+/-0.030	32.00	X		T	
39.00	+/-0.030	39.00	X		T	
48.00	+/-0.030	48.00	X		T	
0.30	+/-0.030	-302	X		V 1B02	
0.30	+/-0.030	-305	X		V	
1.89	+/-0.030	-1884	X		V	
Ø0.19	+0.005/-0.001	.190	X		V	

Measured by:	R	Audited by:	S	Prototype Approval:	N/A
Date:	11-24-10	Date:	11/02/10	Date:	N/A

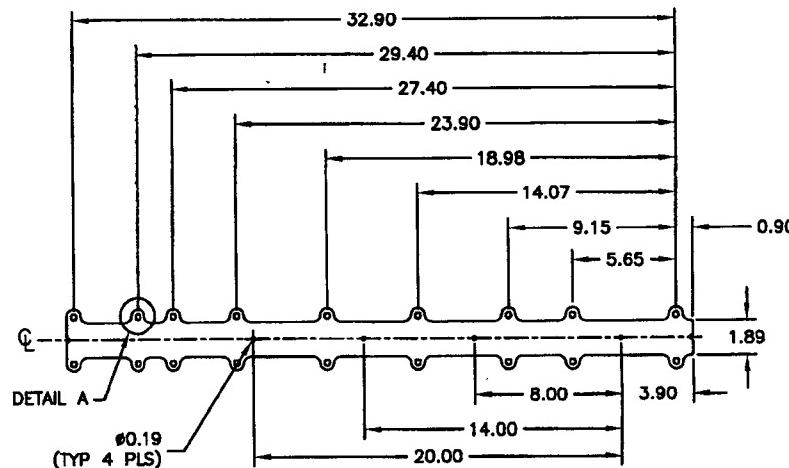
Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/JLM	JM

DART

09.02.12-ff



D3536-11 GASKET



D3536-13 GASKET

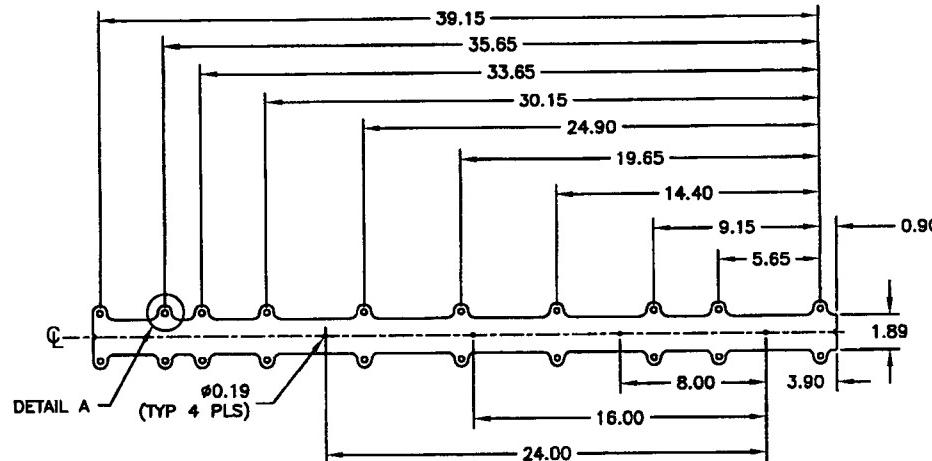
NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

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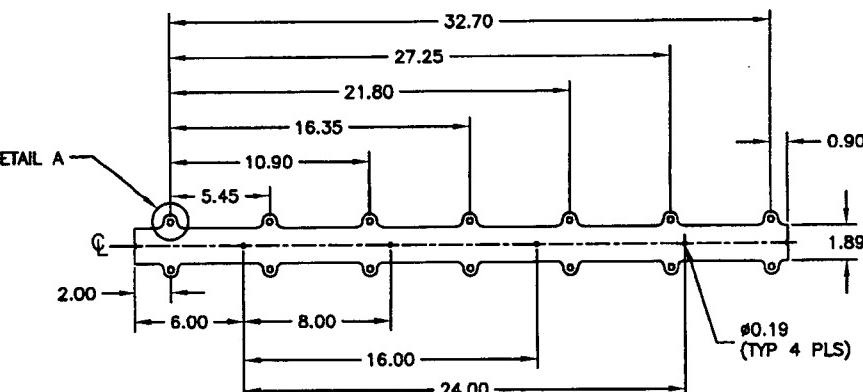
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CHECKED PH	APPROVED PH	DRAWING NO. D3536
DATE 06.10.25	TITLE GASKET	REV. A SHEET 1 OF 6 SCALE 1:10
A	06.10.25	NEW ISSUE

DARTP/N D3536-15
07.02.12**D3536-15 GASKET**

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WORK ORDER
NO. 166-240

NOTES

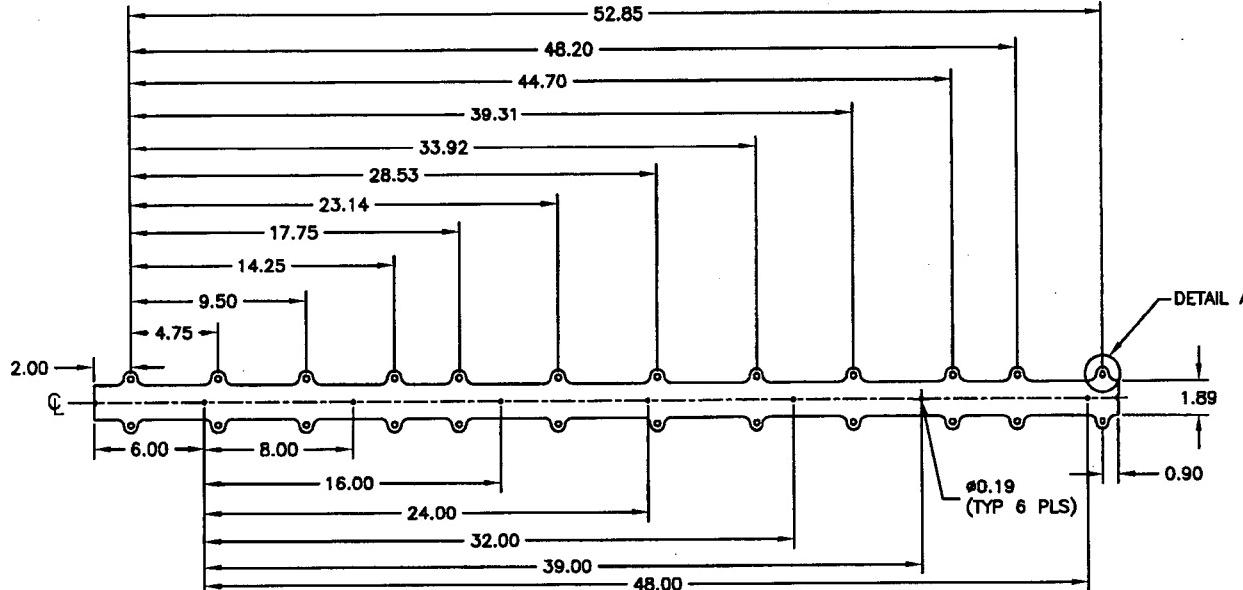
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- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{2}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
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		SHEET 2 OF 6
		SCALE 1:10

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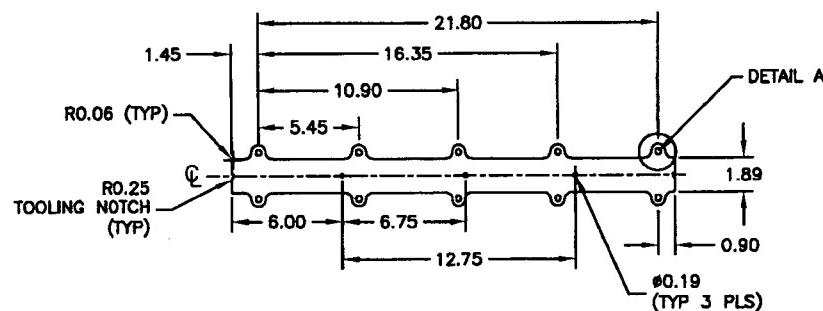


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WORK ORDER
NO. 66240

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT $\frac{1}{4}$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION



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DATE		TITLE
06.10.25		GASKET
REV. A		SHEET 3 OF 6
SCALE		1:10

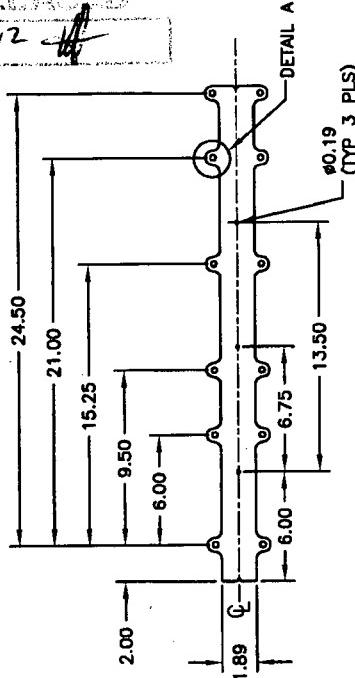
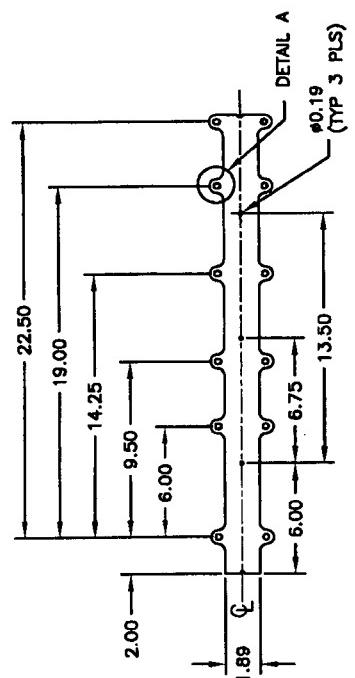
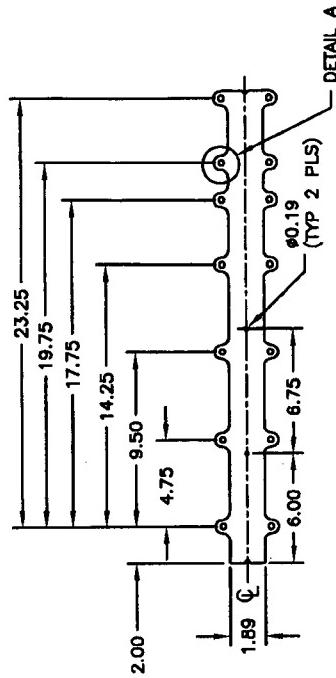
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07.02.02
HJ

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DATE 06.10.25		TITLE GASKET	SCALE 1:10

RELEASED

07.02.12 *[Signature]***D3536-33 GASKET****D3536-31 GASKET****D3536-35 GASKET**

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WORK ORDER
NO 166240

- NOTES:
1) MATERIAL: BLACK NEOPRENE SHEET, $1\frac{1}{16}$ THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S-063)

2) FINISH: NONE

3) PART IS SYMMETRICAL ABOUT $\frac{C}{2}$

4) TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT
PERMANENT INK MARKER

7) SEE PAGE 6 FOR DETAILS AND SECTION

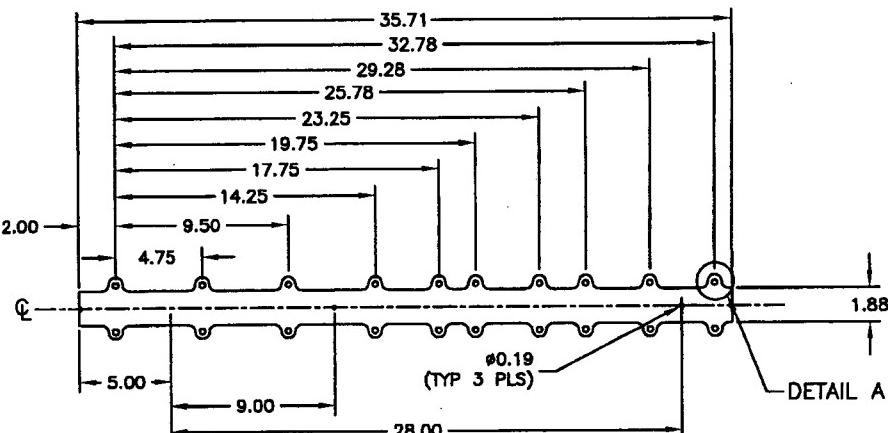
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		SCALE	1:10

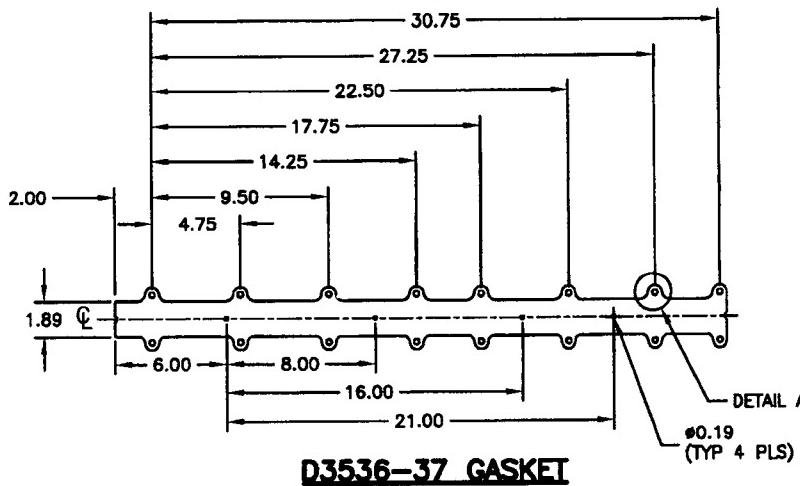


D3536-39 GASKET

NOTES

- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NE060-S.063)
- 2) FINISH: NONE
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) IDENTIFY WITH DART P/N USING A WHITE FINE POINT PERMANENT INK MARKER
- 7) SEE PAGE 6 FOR DETAILS AND SECTION

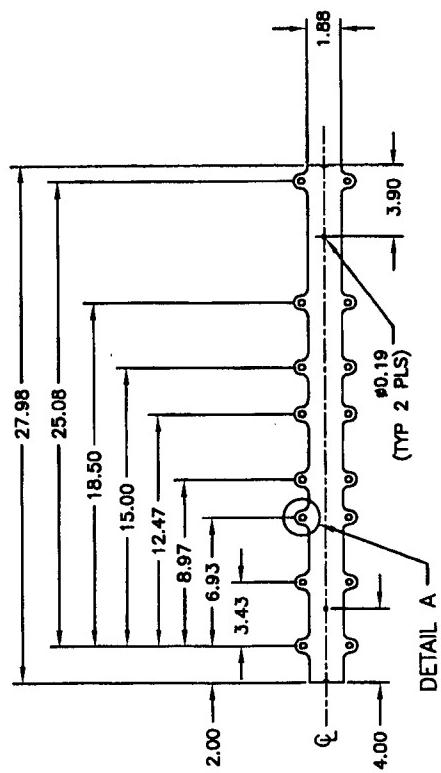
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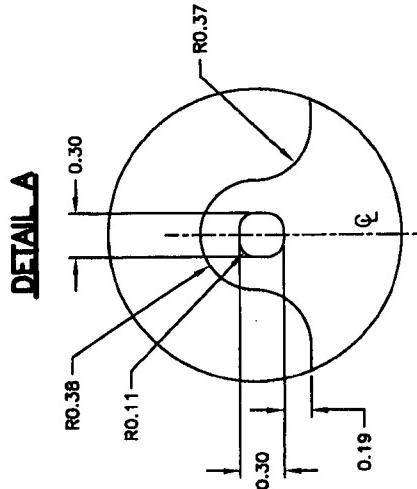
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DATE 06.10.25		TITLE GASKET	SCALE 1:10

07.02.12 **PH****D3536-41 GASKET**

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NO. 660240

- NOTES:
- 1) MATERIAL: BLACK NEOPRENE SHEET, 1/16 THICK, 60 DUROMETER (REF DART SPEC. M-NEO60-S-063)
 - 2) FINISH: NONE
 - 3) PART IS SYMMETRICAL ABOUT $\frac{Q}{2}$
 - 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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